

Work Order ID 84845

84845

Page 1

May-24-12 7:58:50 AM

Item ID: D3690-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Glareshield Assembly
 Start Date: 24/05/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 07/06/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3690	Rev C

100	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

100									
Packaging	Memo	0.00				4	0		FF 12-07-16
Packaging									

110	Small Fab	0.00							
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110									
Small Fab	Memo	0.00				4	0		FF 12-07-16
Small Fab	1- transfer drill D3697-041 and D3698-1 in D3690-1 and assemble as per dwg D3690								
	2- scribe batch # and part # as per dwg								

120	QC5- Inspect part completeness to step on W/O	0.00							
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120									
QC	Memo	0.00							
Quality Control									

DAS
16
2-09

12/04/17

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Revision ID:
 Item Name: Glareshield Assembly
 Start Date: 24/05/2012 Start Qty: 4.00
 Required Date: 07/06/2012 Req'd Qty: 4.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	SprayPaint	0.00							
130									
SprayPaint	Memo	0.00							
Spray Painting	1- Mask hatched areas (6 pls) on inside of the part prior to painting as per dwg 2-Paint D3690-041 assy flat black using Basf Glasurit 22 Line code SFA39.50 per Dart QSI 005 4.2								
140	QC14- Inspect Spray Paint	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <i>PM</i>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

AB 12-8-2 (4)

(x4)

DAS 16 12/08/03

Comp 1/3 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 84845***84845***

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May-24-12 7:58:50 AM

Item ID: D3690-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Glareshield Assembly

Start Date: 24/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCJ 12/08/03

MCJ 12/08/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-24-12 7:58:54 AM

Page 1

Work Order ID: 84845

84845

Parent Item: D3690-041

D3690-041

Parent Item Name: Glareshield Assembly

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-04-29 new issue DD verified by:ec
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec
IPP Rev:C 08-09-08 added painting DD verified by:EC
IPP Rev:D 08-10-07 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD3

Purchased

No

Each

133.0000

8

AN960JD3

Washer

**

(4)

FF 12-07-16

Location

Loc Qty

Loc Code

ST337A

133

107989

133

8

CR3213-4-03

Purchased

No

Each

186.0000

140

CR3213-4-03

rivet

**

(4)

FF 12-07-16

Location

Loc Qty

Loc Code

ST331

165

121243 *

120521

65

121708

100

29

30

ST332

21

116081

21

D3690-1

Manufactured

No

Each

0.0000

4

D3690-1

Glareshield

**

4

(4)

FF 12-07-16

D3697-041

Manufactured

No

Each

2.0000

4

D3697-041

Tube Assembly

**

4

(4)

FF 12-07-16

Location

Loc Qty

Loc Code

ST241A

2

84075

2

B 82735 *
84075

(2)
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

May-24-12 7:58:54 AM

Page 2

Work Order ID: 84845

84845

Parent Item: D3690-041

D3690-041

Parent Item Name: Glareshield Assembly

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 4.00

Required Qty: 4.00

D3698-1

Manufactured No

Each

1.0000

4

D3698-1

Support Angle

**

(4) FF 12-07-16

Location

Loc Qty

Loc Code

ST241A 84074
59244

1

4

1

Each

12,290.00

8

MS20426AD3-5

Purchased

No

MS20426AD3-5

Rivet

**

(4) FF 12-07-16

Location

Loc Qty

Loc Code

ST316
4179
4444
4533

12290

492

5654

6144

8

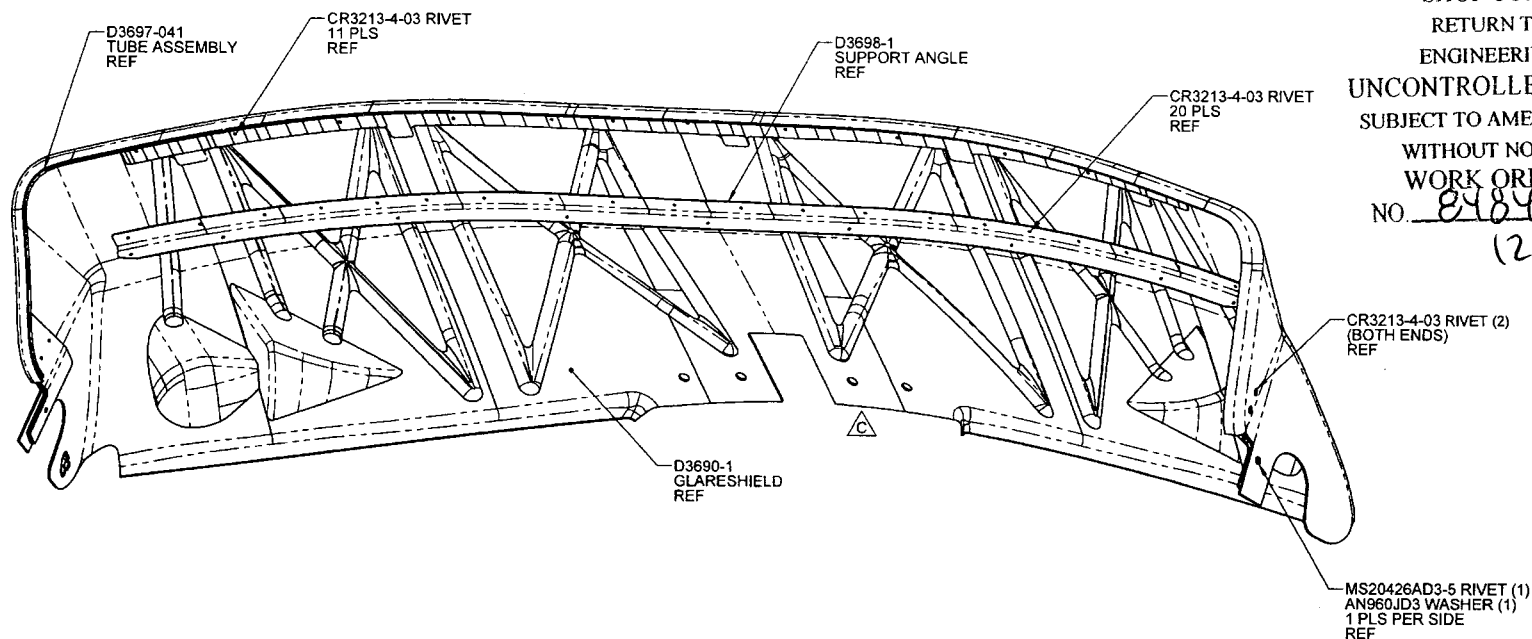
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84845 MLU
12/05/28

RELEASED
28.09.16/18

PART LIST

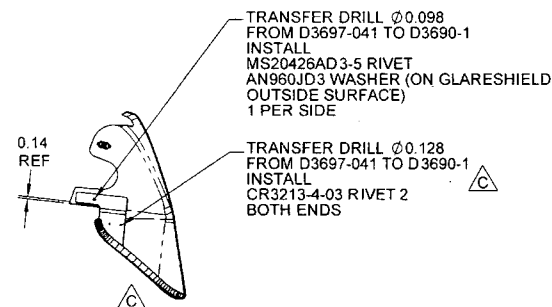
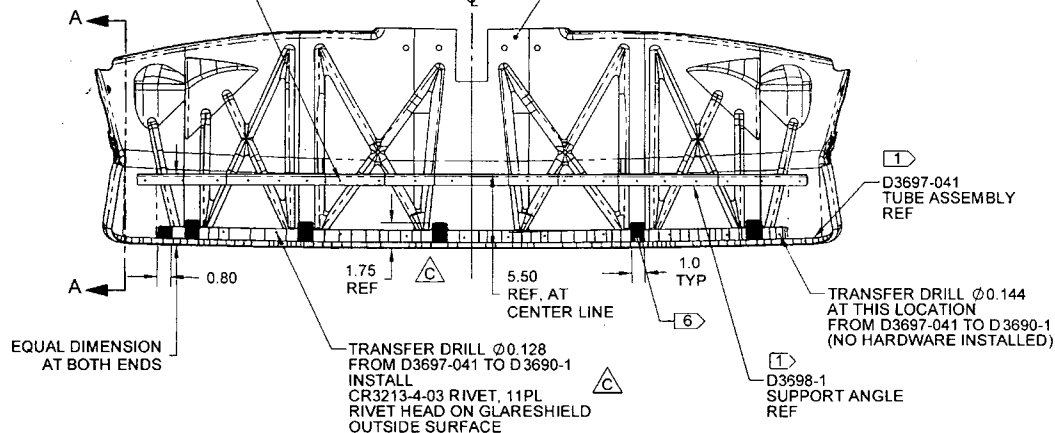
QTY -041	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3697-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
2	AN960JD3	WASHER (OR NAS1149DN332J)
2	MS20426AD3-5	RIVET
35	CR3213-4-03	RIVET

D3690-041 GLARESHIELD ASSEMBLY

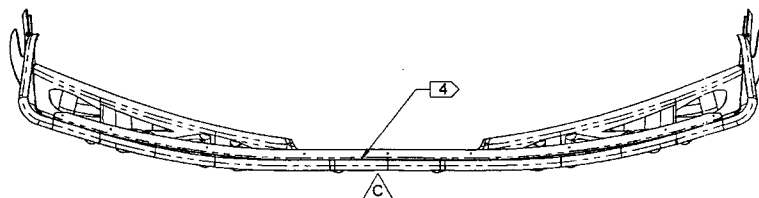
C	SHEET 1 PL MS20426AD3-5 RIVET WAS MS20426AD3-4, CR3213-4-03 RIVET WAS MS20470AD3-4, WASHER QTY WAS 6 (VIEWS UPDATED ACCORDINGLY). RIVETS ON SHEET 1 CHANGED TO REF QTY. RIVETS ON SHEET 2 CHANGED TO "HARD" CALLOUTS. SHADING REMOVED FROM ALL VIEWS FOR CLARITY.	AJS	08.09.02
B	ADD FINISH COAT & 1.0 TYP. SHEET 2 ZONES A.8 & C.5; ADD MIN THICKNESS. SHEET 3 ZONE A.8	RF	08.06.24
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3690	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GLARESHIELD ASSEMBLY	NTS
DATE	08.09.02	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

TRANSFER DRILL $\varnothing 0.128$
FROM D3698-1 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 20 PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

D3690-1
GLARESHIELD
REF



SECTION A-A



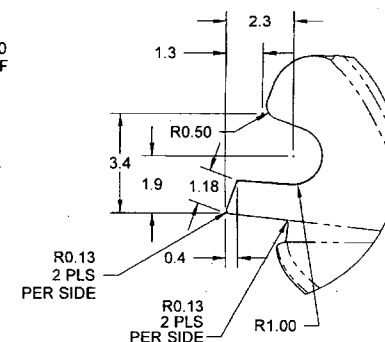
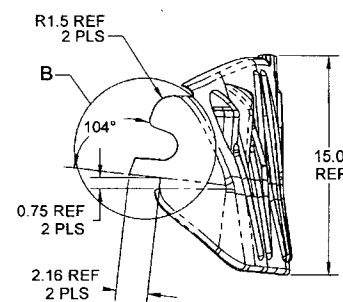
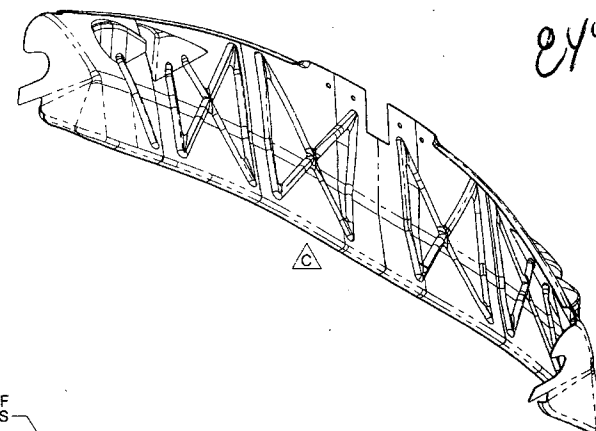
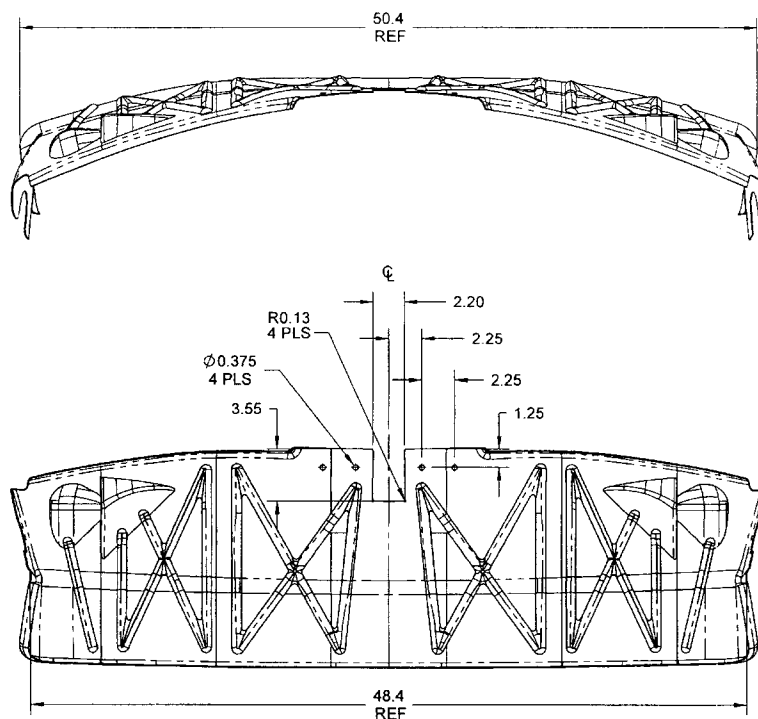
D3690-041 GLARESHIELD ASSEMBLY

NOTES:

- 1) CENTER D3697-041 AND D3698-1 ON TO D3690-1
- 2) FINISH: PAINT D3690-041 ASSY FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50 PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: ETCH WITH DART P/N D3690-041 & B/N ON INSIDE OF PART
- 5) WEIGHT: 2.98 lbs
- 6) MASK HATCHED AREAS (6 PLS) ON INSIDE OF THE PART PRIOR TO PAINTING

RELEASED
08-09-14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3690	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
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D3690-1 GLARESHIELD

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 2) TOOLING: THERMOFORM PER MOLD DT9010 PER QSI 022
TRIM PER MOLD SCRIBE LINES EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.040

RELEASED
08.09.02

DETAIL B
SCALE 2X
THIS VIEW FOR REFERENCE ONLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3690	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
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